

**Work Order ID 60969**

Tuesday, August 03, 2010 9:02:17 AM

Page 1

Item ID: D4017-041

Accept

Setup Start

Revision ID:

Stop

Item Name: Short Basket Base Assembly (350 )

Start Date: 8/4/2010 Start Qty: 1.00

Cust Item ID:

Required Date: 8/10/2010 Req'd Qty: 1.00

Customer:

Reference:

Run Start

Approvals: Process Plan: mf Date: 10-8-03 Tooling:

Date:

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_

Date:

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr

Revision Nbr

D4017

B U/R . PROCEED PER HAND CHANGES.

100

Weld per dwg A/R S.S. rod Batch: 1114649 0.00

Large Fab

Large Fab

Memo

0.00

Large Fab

1- assemble ribs , weld as per dwg D4017 using DT9610B  
\*\*\*inspect before welding mesh\*\*\*  
2- tack weld mesh on basket as per dwg D4017 and trim mesh to fit if necessary  
and trim to clear fasteners holes on the ends  
3- weld hinge (3) and Mounting brackets as per dwg D4017  
\*\*\*take lid to locate hinge and bracket\*\*\*

110

QC9- Inspect visual per QSI004- Fusion Welds 0.00



QC

Memo

0.00

Quality Control

ID 10.08.09

BE 10/08/10

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_




NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action - Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			



**NOTE:** Date & initial all entries




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Item ID:	D4017-041	Accept		Setup	Start	
Revision ID:					Stop	
Item Name:	Short Basket Base Assembly (350 )					
Start Date:	8/4/2010	Start Qty:	1.00	Cust Item ID:		
Required Date:	8/10/2010	Req'd Qty:	1.00	Customer:		
Reference:						

Approvals:	Process Plan:	Date:	Tooling:	Date:	Run	Start	
	QC:	Date:	SPC (Y/N):	Date:		Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120	QC5- Inspect part completeness to step on W/O	0.00							
									
QC	Memo	0.00							
Quality Control									
130	White Gloss(Ref:4.3.5.2) per QSI005 4.3-Steel	0.00							
	*pressure wash								
Powdercoat	Memo	0.00							
Powder Coating	<div>✓ - Plug holes and mask only interior of hinge (3) prior to powder coat</div> <div>118115291</div> <div>1ST COAT:</div> <div>START TIME: 9:15AM</div> <div>OVEN TEMPERATURE: 400°F</div> <div>FINISH TIME: 9:45AM</div> <div>***** 2nd coat if necessary*****</div> <div>2ND COAT:</div> <div>START TIME: 10:00AM</div> <div>OVEN TEMPERATURE: 400°F</div> <div>FINISH TIME: 10:20AM</div>								

10/08/10

⇒ 10/08/10

1 ✓

W/O:		WORK ORDER CHANGES					
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Page 3

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Stop

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Required Date: 8/10/2010 Req'd Qty: 1.00

Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_  
QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Run Start

Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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140

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

*Ep 8/08/10 @*

150

Assemble as per dwg

0.00



HandFinish

Memo

0.00

Hand Finishing

*Ep 8/08/10 @*

160

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

*8/10/06/10**AL*

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Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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Page 4

Item ID: D4017-041

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Setup Start



Revision ID:

Stop



Item Name: Short Basket Base Assembly (350 )

Start Date: 8/4/2010 Start Qty: 1.00



Cust Item ID:

Required Date: 8/10/2010 Req'd Qty: 1.00



Customer:

Reference:

Run Start



Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Stop



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool # Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

170

Identify as per dwg & Stock Location: *B.A* 0.00

Packaging

Memo

*w/o B60967* 0.00

Packaging

*E 50/08/10 @*

180

QC21- Final Inspection - Work Order Release 0.00



QC

Memo

Quality Control

*10/08/11**w 10-08-11*

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# Picklist Print

Tuesday, August 03, 2010 9:02:16 AM

Page 1

Work Order ID: 60969

Parent Item: D4017-041

Parent Item Name: Short Basket Base Assembly (350 )






Start Date: 8/4/2010

Required Date: 8/10/2010

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP RevA: new issue DD 09.11.30 verified by:EC  
per dwg RevA DD 10.03.06 verified by:EC  
DD 10.04.16 verified by:EC  
IPP Rev:B as  
IPP Rev:C as per dwg RevB

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D4017-1 		Manufactured	No			100	Each	0.0000	1	1			
Rib													
D4017-3 		Manufactured	No			100	Each	0.0000	1	1			
Rib													
D4017-5 		Manufactured	No			100	Each	0.0000	1	1			
Hinge Rib													
D4017-7 		Manufactured	No			100	Each	5.0000	1	1			
Rib													
<div> <div>Location</div> <div>Loc Qty</div> <div>Loc Code</div> </div>													
				WA				5					
				58929				2					
				60473				3					
D4017-9 		Manufactured	No			100	Each	4.0000	2	2			
Rib													
<div> <div>Location</div> <div>Loc Qty</div> <div>Loc Code</div> </div>													
				WA				4					
				59984				4					

B60972 -> ① PD 10.08.04

B60970 -> ① PD 10.08.04

B60973 -> ① PD 10.08.04

PD 10.08.04

PD 10.08.04

②

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Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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Work Order ID: 60969

Parent Item: D4017-041

Parent Item Name: Short Basket Base Assembly (350 )

Start Date: 8/4/2010

Required Date: 8/10/2010

Start Qty: 1.00

Required Qty: 1.00

D2581

Manufactured No

100

Each

69.0000

2

2



Mounting Bracket

Location

Loc Qty

Loc Code

WA

69

60198

34

60470

35

100

Each

3.0000

1

1

D3913-15

Manufactured No



Wide Handle Plate

Location

Loc Qty

Loc Code

WA

3

60324

3

100

Each

9.0000

3

3

D4016-1

Manufactured No



Hinge Half, Base

Location

Loc Qty

Loc Code

WA

9

60472

9

100

Each

0.0000

1

1

D4020-3

Manufactured No



Mesh (350 Basket Short, Base)

D4020-11

Manufactured No



End Mesh, Basket

Location

Loc Qty

Loc Code

WA

9

58136

1

59413

2

60584

6

100

Each

9.0000

2

2

PD 10.08.04

②

PD 10.08.04

①

PD 10.08.04

③

B60971 -> ① PD 10.08.5

B60971 -> PD 10.08.05  
B59942 -> ②

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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Page 4

Work Order ID: 60969

Parent Item: D4017-041

Parent Item Name: Short Basket Base Assembly (350 )

Start Date: 8/4/2010

Required Date: 8/10/2010

Start Qty: 1.00

Required Qty: 1.00

D2931 Manufactured No 150 Each 804.0000 2



Bumper



2  
8/10/08/10

Location

Loc Qty

Loc Code

ST504

804

46064

804

2

D4021-1 Manufactured No 100 Each 21.0000 3



Handle Plate



3

8/10/08/04

Location

Loc Qty

Loc Code

ST109

5

57086

5

WA

16

60183

4

60677

12

3

D4021-5 Manufactured No 150 Each 10.0000 2



Blanking Plate



2

8/10/08/10

Location

Loc Qty

Loc Code

ST111

10

60717

10

2

AN3-10A Purchased No 150 Each 55.0000 6



Bolt



6

8/10/08/10

Location

Loc Qty

Loc Code

ST351

55

115016

55

6

AN960JD8 NAS1149DN832J Purchased No 150 Each 0.0000 2



Washer



2

8/10/08/10

4 M115300 (24)

Tuesday, August 03, 2010 9:02:16 AM

Shop Packet Print

Page 4

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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# Picklist Print

Tuesday, August 03, 2010 9:02:16 AM

Page 5

Work Order ID: 60969

Parent Item: D4017-041

Parent Item Name: Short Basket Base Assembly (350 )

Start Date: 8/4/2010

Required Date: 8/10/2010

Start Qty: 1.00

Required Qty: 1.00

MS20600-AD4W3

Purchased

No

150

Each

1,619.000

2

2



Cherry Rivets



*EP 8/10/08/10*

Location

Loc Qty

Loc Code

ST321

1619

106375

3

107939

822

111636

794

MS21042L3

Purchased

No

150

Each

2,466.000

6

6



Nut



*EP 8/10/08/10*

Location

Loc Qty

Loc Code

ST300

2466

114523

115

114718

351

114784

2000

NAS1149F0332P

Purchased

No

150

Each

619.0000

12

12



WASHER



*EP 8/10/08/10*

Location

Loc Qty

Loc Code

ST275

619

18057

619

Tuesday, August 03, 2010 9:02:17 AM

Shop Packet Print

Page 5

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

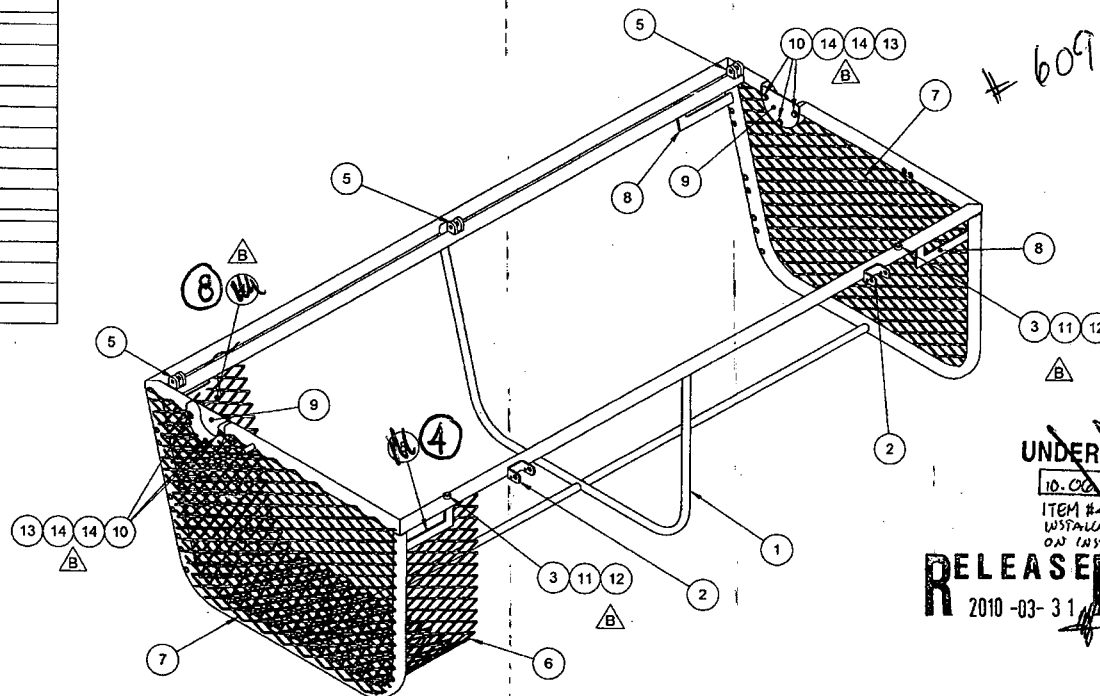
Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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**NOTE:** Date & initial all entries

ITEM	QTY	P/N	DESCRIPTION
	X	D4017-041	SHORT BASKET BASE ASSY (350)
1	1	D4017-101	TUBULAR ASSY (350 SHORT BASKET)
2	2	D2581	MOUNTING BRACKET
3	2	D2931	BUMPER
4	1	D3913-15	WIDE HANDLE PLATE
5	3	D4016-1	HINGE HALF, BASE
6	1	D4020-3	MESH (350 BASKET SHORT BASE)
7	2	D4020-11	END MESH, BASKET
8	3	D4021-1	HANDLE PLATE
9	2	D4021-5	BLANKING PLATE
10	6	AN3-10A	BOLT
11	2	AN960JD8	WASHER
12	2	MS20600AD4W3	RIVET
13	6	MS21042L3	NUT
14	12	NAS1149F0332P	WASHER



**RELEASED**  
2010-03-31

**D4017-041 SHORT BASKET BASE ASSY (350)**  
(MESH SHOWN LOCALLY FOR CLARITY)

**NOTES:**

- 1) MATERIAL: N/A
- 2) FINISH: POWDER COAT WHITE (4.3.5.2) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 28.8 lbs APPROX
- 8) INSTALL AFTER FINISH
- 9) MASK HOLES PRIOR TO POWDER COAT
- 10) WELD PER DART QSI 004

B	QTY 1 D4021-1 REPLACED WITH QTY 1 D3913-15; AN3-10A BOLT WAS AN3C10A; NAS1149F0332P WASHER WAS NAS1149C0332P; SECTION F-F UPDATED (D6-2); ITEMS RENUMBERED; DETAIL D UPDATED (A4-3)	JPH	10.03.25
A	NEW ISSUE	AJS	10.03.04
REV.	DESCRIPTION	BY	DATE
DESIGN	AJS	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWN	JPH		
CHECKED		DRAWING NO.	REV. B
MFG. APPR.		D4017	SHEET 1 OF 5
APPROVED		TITLE	SCALE
DE APPR.		SHORT BASKET BASE ASSY (350)	NTS
DATE	10.03.25	COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PROVIDED IN CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR LOANED OR COPIED OR REPRODUCED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

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Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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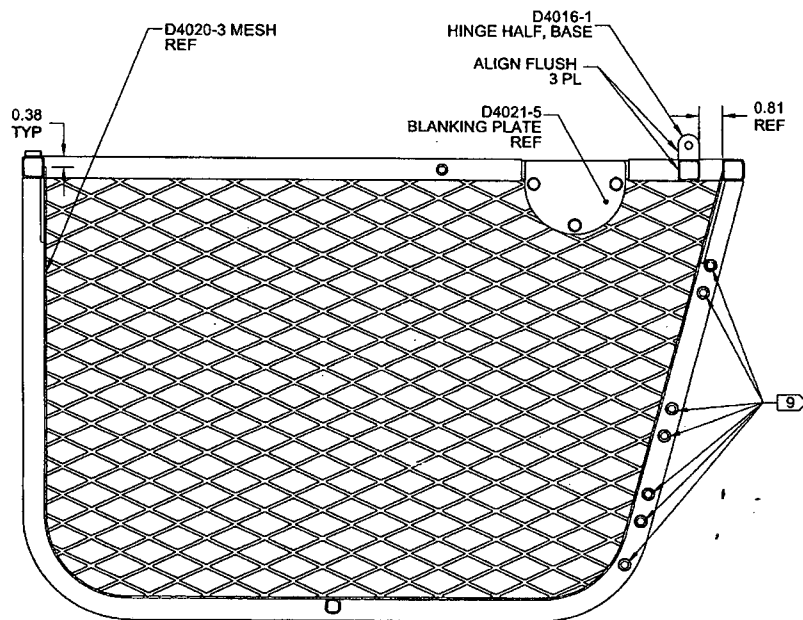
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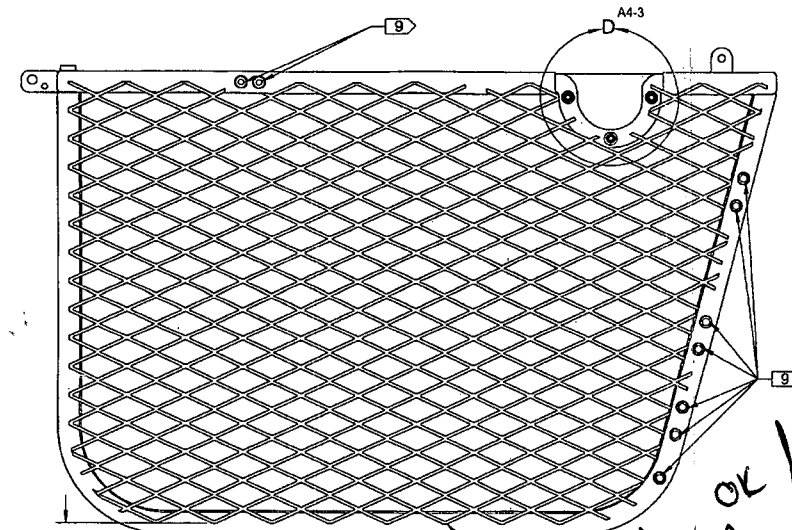
**NOTE:** Date & initial all entries

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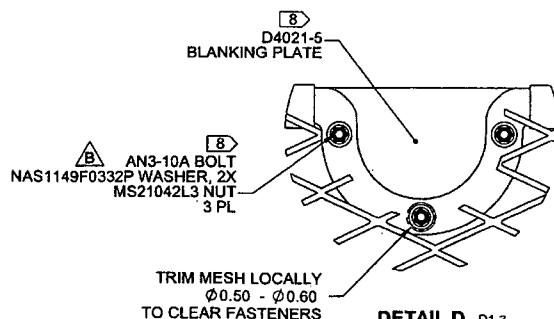
#60969



**SECTION A-A** A5-2



**SECTION B-B** A2-2



**DETAIL D** D1-3 B8-2

UNDER REVIEW

**RELEASED**  
2010-03-31

DESIGN	AJS	<b>DART AEROSPACE LTD</b>	
DRAWN	JPH	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. B
MFG. APPR.		D4017	SHEET 3 OF 5
APPROVED		TITLE	SCALE
DE APPR.		SHORT BASKET BASE ASSY (350)	NTS
DATE	10.03.25	COPYRIGHT © 2010 BY DART AEROSPACE LTD	
THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.			

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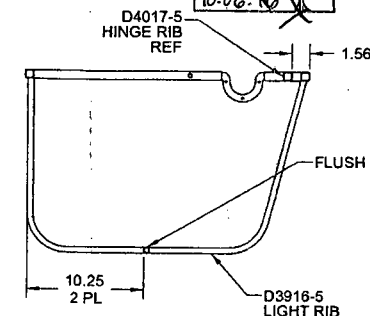
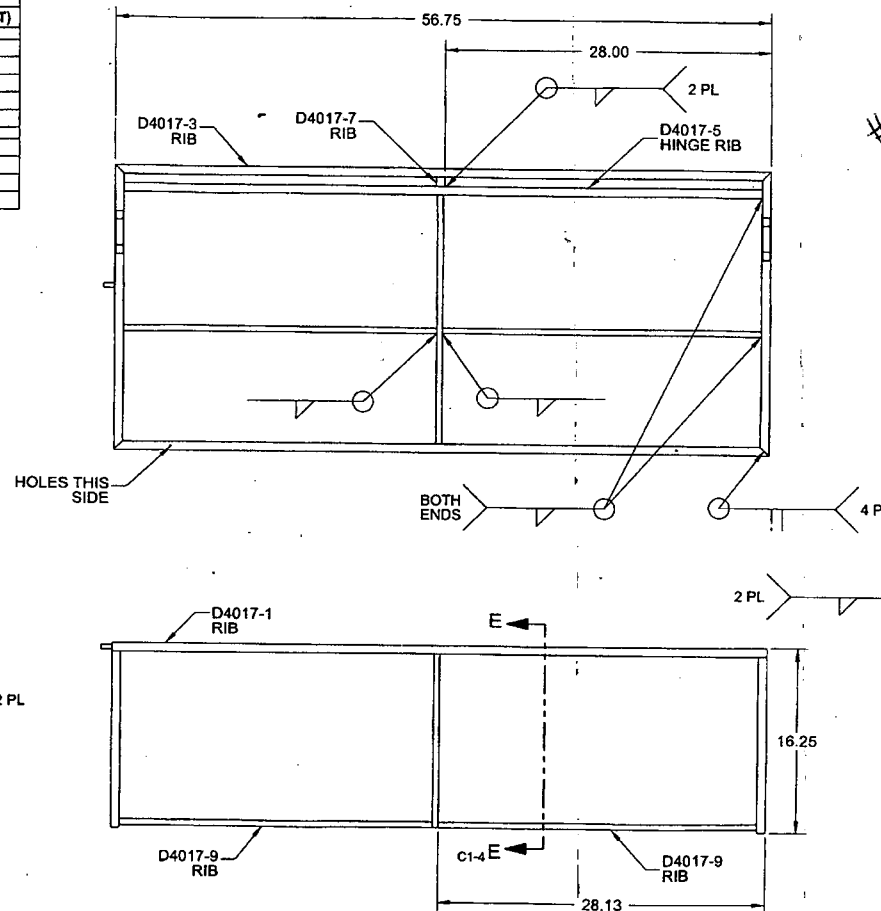
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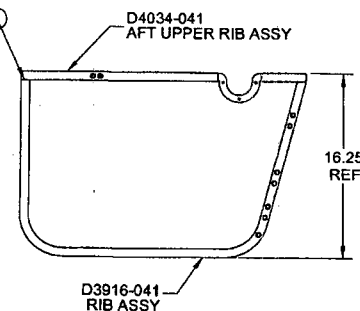
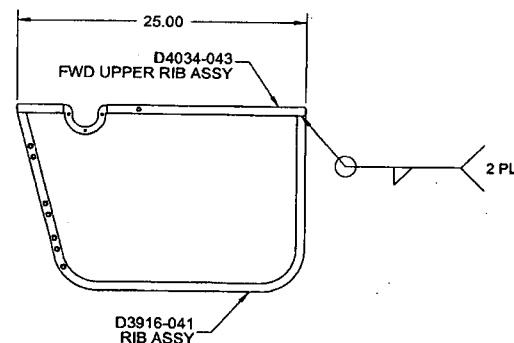
**NOTE:** Date & initial all entries



ITEM	QTY -101	P/N	DESCRIPTION
	X	D4017-101	TUBULAR ASSY (350 SHORT BASKET)
1	1	D4017-1	RIB
2	1	D4017-3	RIB
3	1	D4017-5	HINGE RIB
4	1	D4017-7	RIB
5	2	D4017-9	RIB
6	2	D3916-041	RIB ASSY
7	1	D3916-5	LIGHT RIB
8	1	D4034-041	AFT UPPER RIB ASSY
9	1	D4034-043	FWD UPPER RIB ASSY



SECTION E-E A4-4



- NOTES:
- 1) MATERIAL: N/A
  - 2) FINISH: NONE
  - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
  - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
  - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
  - 6) IDENTIFICATION: N/A
  - 7) WEIGHT: 15.26 lbs
  - 8) TOLERANCE FOR XX.XX DIMENSIONS  $\pm 0.06$  FOR D4017-101
  - 9) WELD PER DART QSI 004

8 D4017-101 TUBULAR ASSY (350 SHORT BASKET)

DESIGN	AJS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	JFH		
CHECKED		DRAWING NO.	REV. B
MFG. APPR.		D4017	SHEET 4 OF 5
APPROVED		TITLE	SCALE
DE APPR.		SHORT BASKET BASE ASSY (350)	NTS
DATE	10.03.25	COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

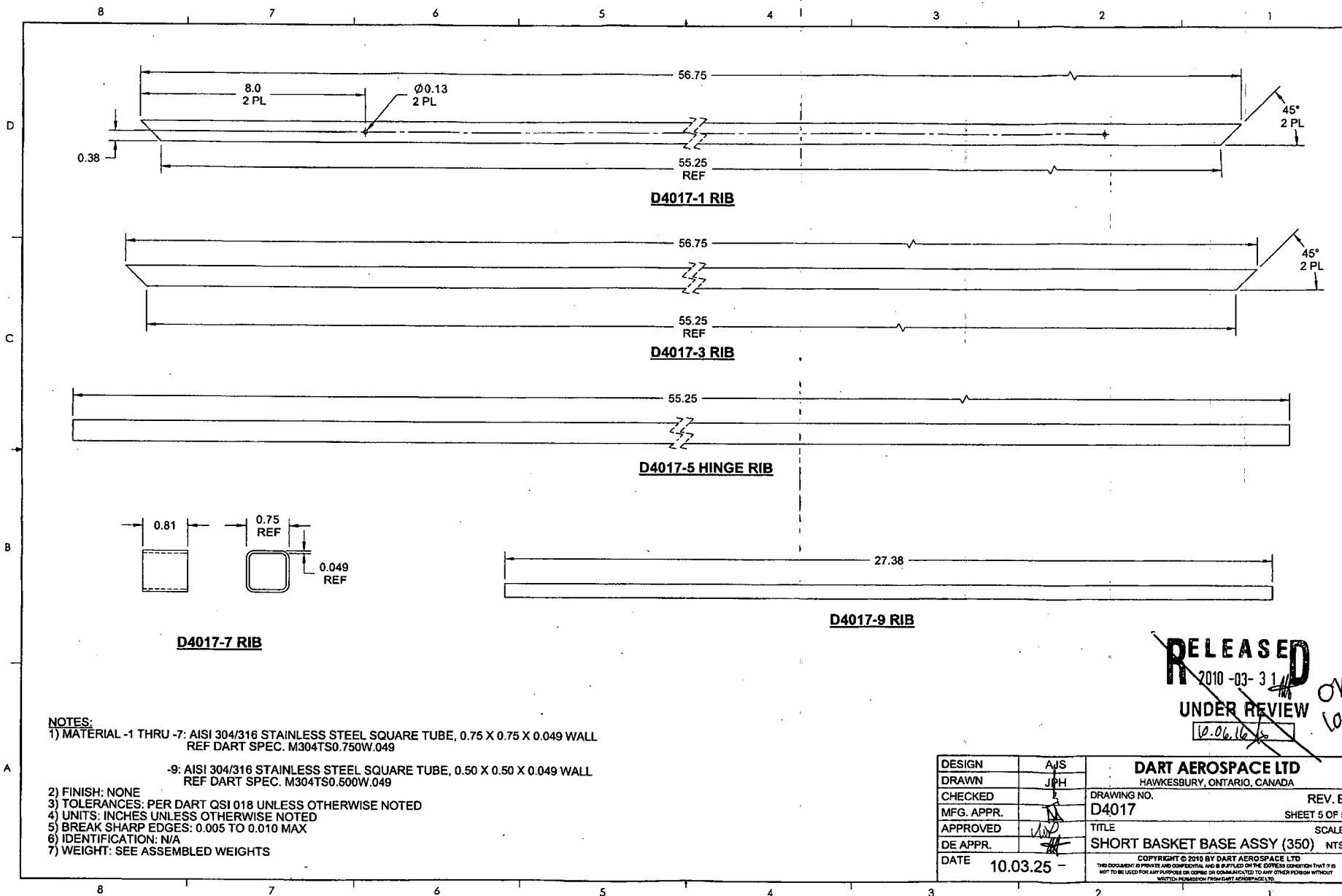
Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

#60969



W/O:		WORK ORDER CHANGES							
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector		

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)							
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector	
			Initial Chief Eng	Action Description Chief Eng	Sign & Date				

**NOTE:** Date & initial all entries